

PATENT ABSTRACTS OF JAPAN

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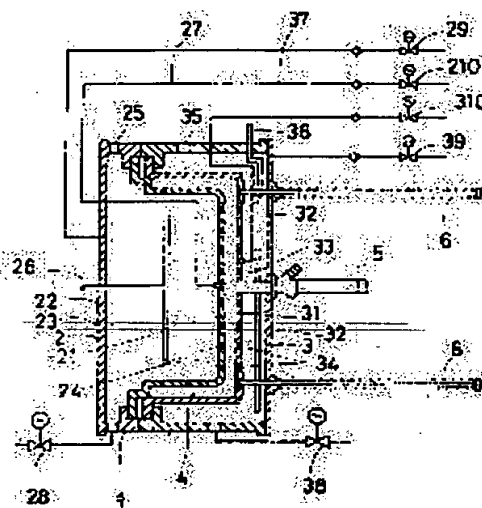
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(54) MANUFACTURE OF FOAMED THERMOPLASTIC RESIN MOLDED BODY

(57)Abstract:

PURPOSE: To discharge residual cooling water completely by a method wherein the foaming molding is cooled, a forming die is opened slightly and compressed air is supplied among both a core die and a cavity die and the foaming molding.

CONSTITUTION: The core die 2 and the cavity die 3 are mold-clamped, and the inside of a die cavity 4 is filled with foaming thermoplastic resin grains. Heat steam is blown into steam chambers 23, 33 from steam supply ports 25, 35, and the foaming molding 7 is formed, and cooling water is introduced into the steam chamber 23, 33 from cooling water pipes 26, 36 to cool the foaming molding 7. Air valves 29, 39 are opened, and the cooling water in the steam chambers 23, 33 is discharged forcibly. The forming die 1 is opened slightly while compressed air is supplied from pressure air pipes 27, 37 mounted to an inside wall 21 of the core die and an inside wall 31 of the cavity die, and cooling water remaining in steam holes 24, 34 is discharged to the outside. The forming die is mold-clamped again, and left as it is cooled naturally, and the foaming molding 7 is mold-released.



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